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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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D4764-5

Job Sheet 201290



Part No: D4764-5

Job Qty: 20 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/19

Job Tracking No:

Due Date: 11/1/19

Created By: Marie Lajeunesse

Type: AOG

Description:

Note: DWG REV B SHEET 2 IPP REV:A NEW ISSUE 13-03-27 JLM VERIFIED BY:DD IPP REV:B 13.11.14 AS PER
DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	20 pcs	11/1/19	11/1/19	0.50	1.52	Hardinge - 1		B1 - 19-10-22
120	QC 8	20 pcs	11/1/19	11/1/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	20 pcs	11/1/19	11/1/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

DAS
5
9-89



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Container No: S224976



Part: D4764-5

Job No: 201290

Serial No/Batch: S224976

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/22/19

DAS

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9-89

19/10/23

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST114
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	20 pcs	11/1/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FB180 & DWG , Descriptions: 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R1.000	303 Round Bar 1.00	1.2500 ft (.0625 ea)	100-Hardinge - 1	S 22 19 10	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M303R1.000	1	19	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.621Inches $+0.008$ -0.001 <i>±0.01</i>	0.629 0.620	<i>0.620</i>	Diameter
2	Bushing	0.075Inches ± 0.010	0.085 0.065	<i>0.076</i>	
3	Bushing	0.210Inches ± 0.010	0.220 0.200	<i>0.215</i>	
4	Bushing	0.750Inches ± 0.010	0.760 0.740	<i>0.751</i>	
5	Bushing	0.060Inches ± 0.010	0.070 0.050	<i>0.061</i>	
6	Bushing	0.010Inches ± 0.010	0.020 0.000	<i>0.010</i>	Radius
7	Bushing	0.990Inches $+0.004$ -0.001 <i>±0.03</i>	0.994 0.989	<i>0.991</i>	Diameter
8	Bushing	0.386Inches $+0.006$ -0.001	0.392 0.385	<i>0.386</i>	Diameter

Plex 9/30/19 1:58 PM Dart.lajeunesse.marie

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐				Date: _____ Sequence #: _____ QTY Affected: _____ MRB (QS1042) ☐	
Description Work Order Deviation		Disposition		Completed By					
Root Cause		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Other/Details: _____							
QC / QA Coordinator		Lead hand / Supervisor		Completed By					